

Claims

1. Support for holding an item of equipment, in particular an item of equipment for a motor vehicle,  
5 comprising a casing of molded plastic (2) having a peripheral wall (4) on which support ribs (16, 18) are provided for holding the item of equipment, the peripheral wall (4) defining a housing of given axis (X-X) for receiving the item of equipment, wherein the  
10 ribs (16, 18) are inclined with respect to the axis (X-X) of the reception housing.
2. Support part according to claim 1, wherein the ribs (16, 18) are formed on the inside of the casing.  
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3. Support part according to claim 1, wherein the ribs (16, 18) each have a salient edge (68) that is able to make contact with the item of equipment.
- 20 4. Support part according to claim 1, wherein the ribs (16, 18) are grouped in pairs having opposite inclinations.
5. Support part according to claim 2, wherein the ribs  
25 (16, 18) are grouped in pairs having opposite inclinations.
6. Support part according to claim 2, wherein the number of ribs (16, 18) is between 4 and 12.  
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7. Support part according to claim 1, wherein the ribs (16, 18) have the shape of a helix (32).
- 35 8. Support part according to claim 3, wherein the ribs (16, 18) have the shape of a helix (32).
9. Support part according to claim 8, wherein the ribs (16, 18) have the shape of a straight line segment

9. Support part according to claim 8, wherein the ribs (16, 18) have the shape of a straight line segment (35) connecting two points (34, 36) situated on a helix (32).

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10. Support part according to claim 8, wherein the shape of the rib (16, 18) corresponds to the shape of a salient edge (68) that the rib has.

10 11. Support part according to claim 8, wherein the angle of inclination of the helix (32) is between 1° and 15°.

12. Support part according to claim 1, wherein the  
15 ribs (16, 18) have a cross section selected from the group comprising triangular, square, rectangular, semi-circular or elliptical shapes, or a combination of these shapes.

20 13. Support part according to claim 2, wherein the ribs (16, 18) have a cross section selected from the group comprising triangular, square, rectangular, semi-circular or elliptical shapes, or a combination of these shapes.

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14. Support part according to claim 4, wherein the ribs (16, 18) have a cross section selected from the group comprising triangular, square, rectangular, semi-circular or elliptical shapes, or a combination of  
30 these shapes.

15. Support part according to claim 6, wherein the ribs (16, 18) have a cross section selected from the group comprising triangular, square, rectangular, semi-circular or elliptical shapes, or a combination of  
35 these shapes.

16. Support part according to claim 7, wherein the ribs (16, 18) have a cross section selected from the group

comprising triangular, square, rectangular, semi-circular or elliptical shapes, or a combination of these shapes.

- 5 17. Support part according to claim 1, wherein the cross section of the ribs is constant, increasing or decreasing, or has a combination of these forms.
- 10 18. Support part according to claim 2, wherein the cross section of the ribs is constant, increasing or decreasing, or has a combination of these forms.
- 15 19. Support part according to claim 4, wherein the cross section of the ribs is constant, increasing or decreasing, or has a combination of these forms.
- 20 20. Support part according to claim 6, wherein the cross section of the ribs is constant, increasing or decreasing, or has a combination of these forms.
- 21 21. Support part according to claim 7, wherein the cross section of the ribs is constant, increasing or decreasing, or has a combination of these forms.
- 25 22. Support part according to claim 2, wherein the ribs (16, 18) are continuous.
- 23 23. Support part according to claim 4, wherein the ribs (16, 18) are continuous.
- 30 24. Support part according to claim 7, wherein the ribs (16, 18) are continuous.
- 35 25. Support part according to claim 1, wherein the ribs are formed by a series of bosses (64, 66) arranged along a line (32) that is inclined with respect to the axis (X-X) of the housing.

along a line (32) that is inclined with respect to the axis (X-X) of the housing.

27. Support part according to claim 25, wherein the  
5 bosses (64, 66) are arranged along a helical line (32).

28. Support part according to claim 25, wherein the  
bosses (64, 66) are arranged along a straight line  
segment (35) connecting two points (34, 35) situated on  
10 a helix (32).

29. Support part according to claim 27, wherein the  
bosses (64, 66) have points of contact defining salient  
edges (68) of the ribs.

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30. Method of molding a support part (2) comprising  
support ribs (16, 18) for holding an item of equipment,  
the step comprising:

20 - providing a mold consisting of at least two cores  
(38, 40);

- bringing the two cores (38, 40) toward one another in  
a given direction (D) such that, once positioned, the  
latter are in contact with one another along a parting  
25 plane;

- filling the mold with a moldable material;

- moving the cores (36, 38) apart from one another in  
the given direction (D),

wherein the support ribs (16, 18) are provided on the  
30 molded part with an inclination ( $\alpha$ ) with respect to the  
given direction (D); the cores (16, 18) are shaped such  
that their parting plane follows the ribs (16, 18), and  
a clearance (62) is provided in at least one of the  
cores (38, 40) in the region of their parting plane in  
35 order to form the ribs, during molding, by the filling  
of this clearance (62) with the molded material.

31. Method according to claim 30, wherein the cores (38, 40) are shaped such that their parting plane forms salient edges (68) of the ribs (16, 18).

5 32. Mold for implementing the method according to claim 30, comprising an upper core (38) having a cylindrical central portion (42) and peripheral protrusions (46), and a lower core (40) having a cylindrical central portion (44) and peripheral  
10 protrusions (48).

33. Mold for implementing the method according to claim 31, comprising an upper core (38) having a cylindrical central portion (42) and peripheral protrusions (46),  
15 and a lower core (40) having a cylindrical central portion (44) and peripheral protrusions (48).

34. Mold according to claim 32, wherein each peripheral protrusion (46) of the upper core (38) has  
20 an outer cylindrical face (50), an inner cylindrical face (54) and radial faces (58) connecting the outer cylindrical face (50) and the inner cylindrical face (54), and in that each peripheral protrusion (48) of the lower core (40) has an outer cylindrical face (52),  
25 an inner cylindrical face (56) and radial faces (60) connecting the outer cylindrical face (52) and the inner cylindrical face (56).

35. Mold according to claim 32, wherein the radial  
30 faces (58, 60) are planar or helical.

36. Mold according to claim 33, wherein the radial faces (58, 60) are planar or helical.

35 37. Mold according to claim 34, wherein the radial faces (58, 60) are planar or helical.

38. Mold according to claim 32, wherein it comprises a clearance (62) in at least one of the cores (38, 40) in

the region of their parting plane in order to form the ribs (16, 18) during molding.

39. Mold according to claim 34, wherein a clearance  
5 (62) is formed by a connecting face connecting an outer cylindrical face (50) and a radial face (58) of the upper core (38) and/or by a connecting face connecting an outer cylindrical face (52) and a radial face (60) of the lower core (40).

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40. Mold according to claim 34, wherein a clearance  
(62) is formed by a connecting face connecting an outer cylindrical face (50) and a radial face (58) of the upper core (38) and/or by a connecting face connecting  
15 an outer cylindrical face (52) and a radial face (60) of the lower core (40).